

shp April 20

# Work Order ID 82226

\*82226\*

Page 1

March-27-12 7:43:54 AM

Item ID: D4314-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Shim

Stop \*NS2\*

Start Date: 27/03/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/27 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4314

A

100

0.00

\*100\*

FLOW WATER JET

0.00

B12-4-7

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D4314

6561.188

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

B12-4-7

QC

Memo

0.00

Quality Control

120

0.00

\*120\*

QC8- Inspect parts - second check

Sizelator

QC

Memo

0.00

Quality Control

(+17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Required Date: 20/04/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

COUNTER SINK AS PER DWG

17x ~~1~~ ~~12/04/10~~

150

**\*150\***

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

Sizku/10

(47)

160

**\*160\***

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

17 ~~1~~ ~~12-4-11~~

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC3- Inspect Part Finish

0.00

**\*170\***

QC

Memo

0.00

Quality Control

17.   12/04/11

180

Identify as per dwg & Stock Location: ST-139C 0.00

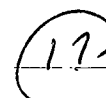
**\*180\***

Packaging

Memo

0.00

Packaging

(17)  12/04/11 JB

190

QC21- Final Inspection - Work Order Release

0.00

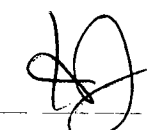
**\*190\***

QC

Memo

0.00

Quality Control

12/4/12 

12-04-11

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**NOTE:** Date & initial all entries

# Picklist Print

March-27-12 7:43:58 AM

Page 1

Work Order ID: 82226

\*82226\*

Parent Item: D4314-3

\*D4314-3\*

Parent Item Name: Shim

Start Date: 27/03/2012

Required Date: 20/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188		Purchased	No			100	sf	25.4700	0.0194	0.204211	5		

\*M6061T6S 188\*

6061-T6 .188 Sheet

\*\*

HB12-4-7

Location

Loc Qty

Loc Code

MAT021

25.47

116604

25.47

116604

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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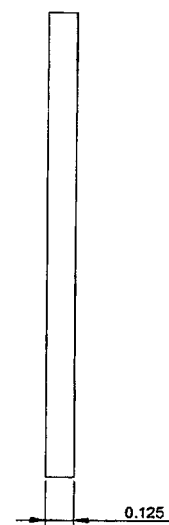
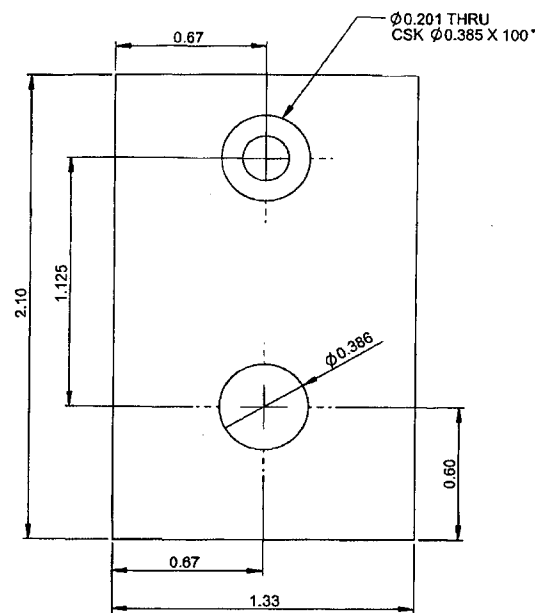
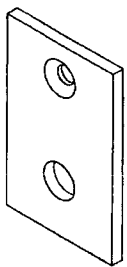
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NOTE: Date & initial all entries



SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 82226 MLJ  
12/03/27

**D4314-1 SHIM**

RELEASED  
2011-02-11  
*MB*

**NOTES:**

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125)  
OR  
ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11  
AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M8061T6S.125)  
OR  
ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A250/8  
AMS 4018 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

A		NEW ISSUE		SC	11.01.13
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	SC				
CHECKED	<i>[Signature]</i>	DRAWING NO.	D4314	SHEET 1 OF 2	
MFG. APPR.	<i>[Signature]</i>	TITLE	SHIM	SCALE	
APPROVED	<i>[Signature]</i>	DATE		NTS	
DE APPR.	<i>[Signature]</i>	11.01.13		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED, COPIED, OR OTHERWISE USED TO REPRODUCE ANY PART OF THE PRODUCT OR PROCESS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

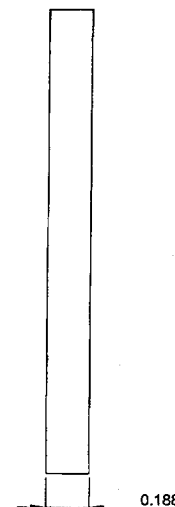
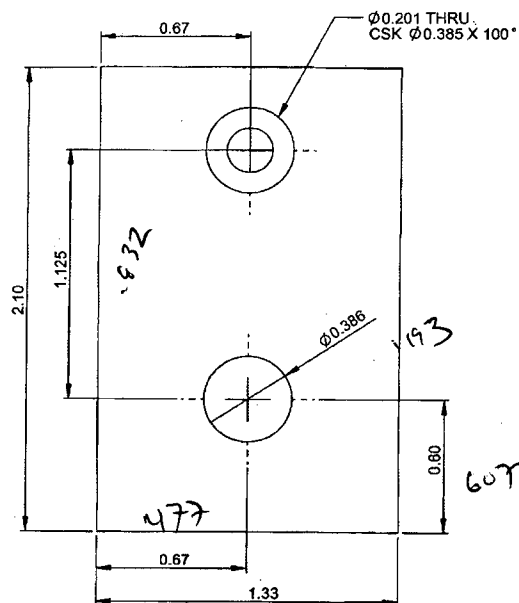
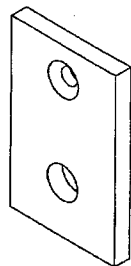
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**D4314-3 SHIM**

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

**RELEASED**  
2011-02-01  
WP

DESIGN	SC	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	<b>D4314</b>	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	<b>SHIM</b>	NTS
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